

Date: Monday, 02/02/2009 4:04:31 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SINGLE MIRROR ASSEMBLY
Job Number	: 45431		
Estimate Number	: 13728		
P.O. Number	:	Part Number	: D407558045
This Issue	: 02/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: DSI9436 REV.A
First Issue	: / /	Project Number	: N/A
Previous Run	:	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 21/02/2009
Checked & Approved By	: <u>JD 09.02.03</u>	Qty:	3 Um: Each
Comment	: Est Rev:A 09-01-15 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL



JD 09/03/11
D407-558-015



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP DSI 9436 CHG001

S 09/03/10

2.0

D2011101

6" Mirror



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Mirror 6"

Pick:

Qty Part Number Description Batch

1 D2011-101 Mirror

B43793

EP 09/03/10

3.0

D2065

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Arm

B45543

EP 09/03/10

4.0

D2052

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bracket

Pick:

Qty Part Number Description Batch

2 D2052 Bracket

B39556

EP 09/03/10

5.0

D2054

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bushing - Delrin

Pick:

B39433

EP 09/03/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SINGLE MIRROR ASSEMBLY

Job Number: 45431

Part Number: D407558045

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description Batch
2 D2054 Bushing

6.0

D2055

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Clamp

Pick:

Qty Part Number Description Batch
1 D2055 Clamp

B34365

Ep 09/03/10

7.0

D2056

Bell Crank



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Bell Crank Assembly

Pick:

Qty Part Number Description Batch
1 D2056 Bellcrank

B39434

Ep 09/03/10

8.0

D2057

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Plug

Pick:

Qty Part Number Description Batch
1 D2057 Plug

B40048

Ep 09/03/10

9.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer

Pick:

Qty Part Number Description Batch
4 AN960JD10 Washer

M110139

Ep 09/03/10

10.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Nut

Pick:

Qty Part Number Description Batch
2 MS21042L3 Nut
or MS21042-3

M110399

Ep 09/03/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: SINGLE MIRROR ASSEMBLY

Job Number: 45431

Part Number: D407558045

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-18

Screw

M108161

EP09/03/10

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-558

EP09/03/10 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/10 (3)

14.0

D37781

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket

batch:

1541958

SP

15.0

D2053

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2053

Bracket

1538531

SP

16.0

D2067

Connector



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Connector

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2067

Connector

1539558

9/3/11

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45431

Part Number: D407558045

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D20713

Cable



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Cable Assembly

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2071-3	Cable	1545004

18.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	AN3-4A	Bolt	M103611

19.0

AN5261032R9

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	AN526-1032R9	Screw	M101189
	or AN526C1032R9		

20.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

Batch: M110399

21.0

AN960JD10L

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
6	AN960JD10L	Washer	M109632

9/3/11

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45431

Part Number: D407558045

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

MS21919DG5

Clamp



3X

Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Clamp

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21919DG5 Clamp

or MS21919WDG5

M107012

9/3/11

50

23.0

MS3548967

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Grommet

Pick: Packing Kit

Qty Part Number Description Batch

1 MS35489-67 Grommet

M111193

9/3/18 3X

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9/3/18 4X

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP DSI 9436

Location:

PPP Rev:

42

9/3/18

3X

50

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/19

Job Completion



MF
09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-558 REV. C OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-558 REV. 0

REF: CANADIAN STC SH92-17

REF: FAA STC SH1031NE

IT HAS COME TO DART'S ATTENTION THAT A LONGER CABLE IS REQUIRED WHEN INSTALLING THE DART D206-558-041/-043 SINGLE/DUAL CARGO MIRROR ASSEMBLY ON A BHT 407 AIRCRAFT. THIS IS DUE TO THE MIRROR INSTALLATION BEING MOVED FORWARD TO PICK UP ON EXISTING SET OF SCREW HOLES ON THE BELLY OF THE AIRCRAFT AS SHOWN IN FIGURE 3 OF INSTALLATION INSTRUCTIONS D206-558 REV. C OR EARLIER.

IT IS ACCEPTABLE TO REPLACE THE D2071 CABLE ASSEMBLY WITH D2071-3 CABLE ASSEMBLY. FURTHERMORE, IT MAY BE NECESSARY TO REPLACE THE MS35489-9 GROMMET WITH MS35489-67 GROMMET TO ACCOMMODATE A POSSIBLE VARIANCE IN MATERIAL THICKNESS ON A BHT 407 AIRCRAFT AS OPPOSED TO A BHT 206 AIRCRAFT.

CUSTOMERS INSTALLING EXISTING D206-558-041/-043 KIT ON A BHT 407 AIRCRAFT MUST PROCURE THE FOLLOWING KIT FROM DART:

DSI 9436-011 PARTS LIST:

Qty -011	Part Number	Description
X	DSI 9436-011	CABLE CHANGE KIT
1	D2071-3	CABLE ASSEMBLY (REPLACES D2071)
1	MS35489-67	GROMMET (REPLACES MS35489-9)

INSTALL THE D2071-3 CABLE ASSEMBLY AND MS35489-67 GROMMET PER INSTALLATION INSTRUCTIONS D206-558 REV. C OR EARLIER AND MAINTAIN PER ICA-D206-558 REV. 0.

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 08.12.04
CERT. NO.: SH92-17
ISSUE NO.: 7

A	NEW ISSUE	MB	08.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>1A</u>	DART AEROSPACE LTD	
DRAWN	<u>2</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PL</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>N/A</u>	DSI 9436	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	CABLE CHANGE	NTS
DATE	08.12.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

FROM THIS POINT FORWARD, CUSTOMERS SHOULD ORDER D407-558-045/-047 IN LIEU OF D206-558-041/-043 WHEN PROCURING SINGLE/DUAL MIRRORS FOR BHT 407 MODELS. AMEND SECTIONS 4.0 AND 5.0 OF INSTALLATION INSTRUCTIONS D206-558 REV. C OR EARLIER AND 25.3 AND 25.4 OF ICA-D206-558 REV. 0 AS FOLLOWS:

4.0 WEIGHT AND BALANCE (D206-558 REV. C OR EARLIER)

25.3 WEIGHT AND BALANCE (ICA-D206-558 REV. 0)

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
D407-558-045	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 407	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D407-558-047	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 407	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg

5.0 PARTS LIST (D206-558 REV. C OR EARLIER)

25.4 PARTS LIST (ICA-D206-558 REV. 0)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
1	2	1	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054	BUSHING
1	1	1	1	D2055	CLAMP
1	1	1	1	D2056	BELLCRANK ASSEMBLY
1		1		D2057	PLUG
1		1		D2065	ARM
	1		1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	1	D2071-3	CABLE ASSEMBLY
1	2	1	2	D3014-1	* LOCKNUT
1	1	1	1	D3778-1	BRACKET
4	4	4	4	AN3-4A	BOLT
4	4	4	4	AN526-1032R9	SCREW
1	2	1	2	AN960JD416L	* WASHER
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD10L	WASHER
3	3	3	3	MS21042-3	NUT (or MS21042L3)
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
		1	1	MS35489-67	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.12.04
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9436	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CABLE CHANGE	NTS
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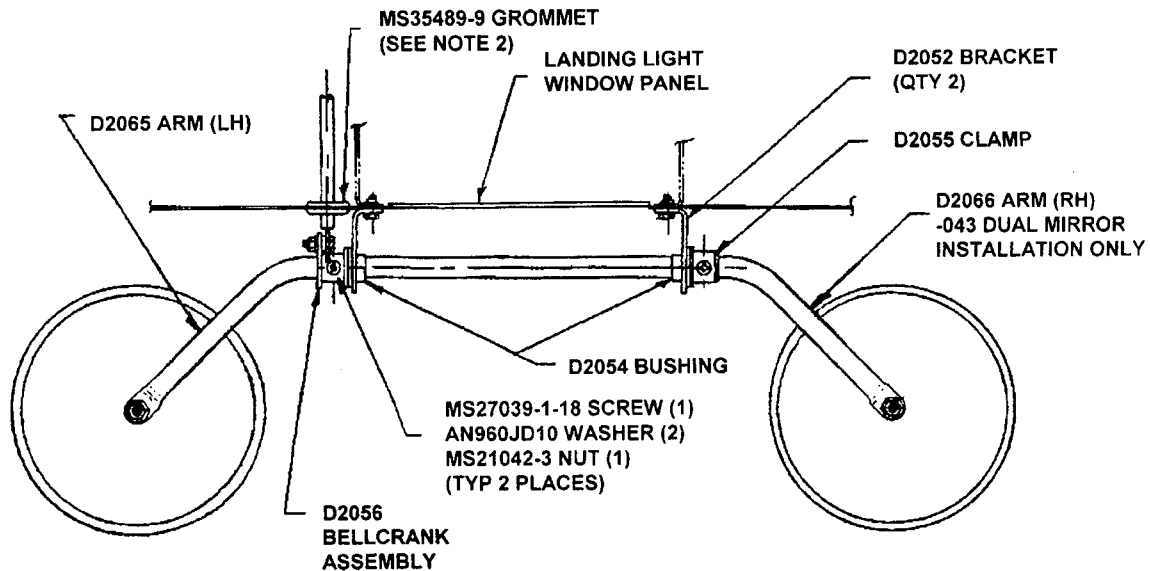


Figure 25.2 – View A: Looking Aft.
(D206-558-043 Mirror Shown)

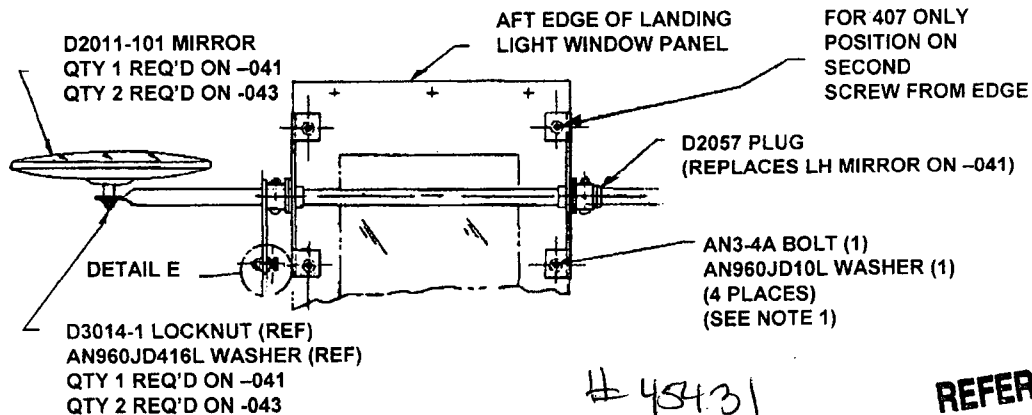


Figure 25.3 – View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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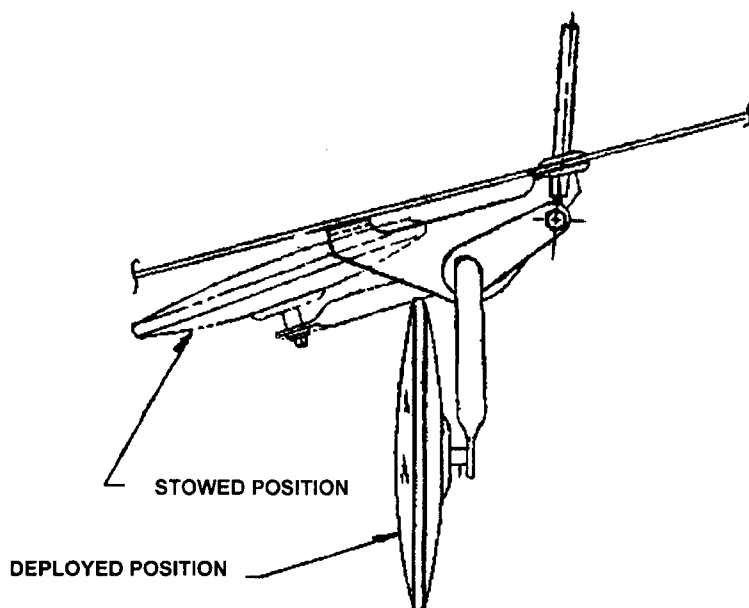


Figure 25.4 – Detail D: Looking from Side on Mirror Installation
(D206-558-041/-043 Mirror Shown)

REFERENCE ONLY

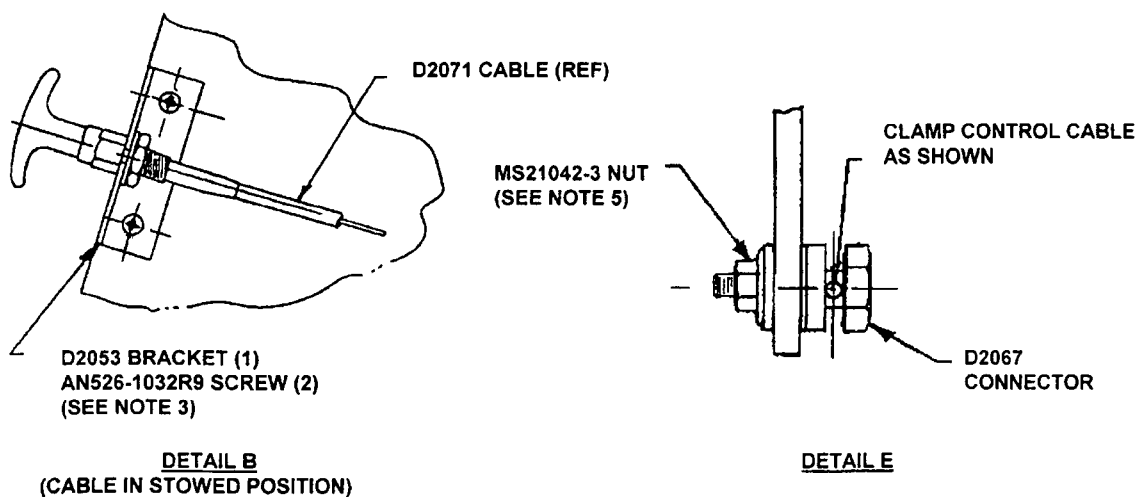


Figure 25.5 – Details B and E on Mirror Installation
(D206-558-041/-043 Mirror Shown)

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